

REVISION HISTORY					
DATE	REV	DESCRIPTION	AUTHOR	CHECKED BY	APPROVED
06/02/16	PR2	ADDED -19 AND -20 TO THE -100; CHANGED THE -102; ON THE -119 MAKE FROM WAS ES04020-1 AND WIDTH WAS 12.18.	JT	LS	JT
08/04/16	PR3	UPDATED PICTORIALS OF -100, -10 AND -120; FOR -110, CHANGED LENGTH FROM 22.000 TO 21.624; CHANGED THE -117 TUBE WITH A 5.7° BEND; CHANGED THE -127 FOR HOLE PLACEMENT; REMOVED THE -115; ON THE -122 AND -123, REPLACED THE -115 WITH THE -127; REMOVED DIMS ON -112 FLAT PATTERN SINCE SAME AS -111.	JT	LS	JT
03/09/17	A	ADDED SHEET 1 FOR THE REVISION BLOCK; UPDATE FINISH ON -101, -102, -103, -104, -105, -106, -108, -110, -111, -112 AND -127; ON -105 CHANGED TOLERANCE ON 12.644 WAS +/-0.010, CHANGED THE 0.266 DIA. HOLES TO SLOTS; ON -110 CHANGED DIM. 20.579 TO 19.534 AND REFERENCE POINT, CHANGED 0.201 DIA HOLES 2 PLACES TO 0.175; ON -111 CHANGED TOLERANCE OF 0.125 DIA. WAS +/-0.010, CHANGED 0.201 DIA HOLE TO 0.175; ON -127 CHANGED RIVET HOLES WAS 0.093/0.103 DIA; ON -20 REMOVED '505AC-601' FROM NOTE 2, CHANGED MINIMUM LENGTH IN NOTE 3 WAS 6", ADDED A WIRING DIAGRAM; ON -109 CORRECTED RIVET SIZE WAS MS20470AD2-2-5; ON -101, -103 AND -106 ADDED DIMENSIONS; ADDED MASK AREAS ON -101,-102, -103, -104, -105, -106, -108, -110, -111, -112 AND -127; UPDATED NOTES AND ADDED BONDED AREA CALLOUTS TO -100, -109, -120, -121, -122 AND -123; ON -100, REMOVED THE MS20470ad3-3-5 RIVETS AS THEY ARE APART OF -120.	JT	LS	JT
3/29/2017	B	REPLACED NAS1149CO0332R, NAS1149CO463R, NAS1149CN816R WITH NAS1149F____P; REPLACED MS21043-XX NUTS WITH MS21042-XX NUTS. 505AC-2300 -111 AND -112 MATERIAL THICKNESS WAS .030", ADDED BEND TABLE TO PG 21, -101 TAPE TEST WAS ONCE PER MONTH.	EW	LS	JT
6/1/17	C	ADDED ITEM 6 SHT 4	EW	LS	JT
7/19/17	D	FILLED IN CHECKED BY AND APPROVED INITIALS REVS PR2 TO C; SHT 2 BOM ITEM 14 WAS MS21042L3, BOM ITEM 21 WAS NAS43DD3-20; SHT 5 BOM ITEM 3 WAS MS20470AD3-2-5; SHT 6 BOM ITEM 4 WAS MS20470AD3-3-5, REV B & C AUTHOR WAS ETW & KEW.	EW	LS	JT
10/17/17	E	ADDED R0.156 EDGE RELIEF TO -111 AND -112.	EW	LS	JT
02/20/18	F	SHT 2 ITEM 1 WAS 505AC-2300-010, ITEM 2 WAS 505AC-2300-020, REMOVED ITEM 12, ITEM 20 WAS NAS1149FN816R, ITEM 22 QTY WAS A/R PART NUMBER WAS IUBOIC-33; SHT 3 REPLACED HARDWARE & TUBES WITH NEW -11 & -12 SUB ASSEMS; ADDED NEW SHT 4 -11 & -12 DETAILS; SHT 5 ITEM 5 QTY WAS 2, PART NUMBER WAS MIL-W-22759/41-16-8, DESCRIPTION WAS WIRE, ADDED ITEMS 7 AND 8 TO PARTS LIST, ADDED POLARITY NOTES AND PIN NUMBERS TO WIRING DIAGRAM, ADDED NOTE 4; SHT 7 ITEM 4 WAS MS20470AD3-3.5, ADDED ITEM 5; SHT 9 & 10 ADDED NOTE 5; SHT 15 -105 BEND RADIUS WAS 0.040"; SHT 16 -106 BEND RADIUS WAS 0.060"; ADDED BEND CHARTS & BEND CALLOUTS TO -101, -103, -105, -108, -110, -111, -112.	EW	LS	JT
7/3/18	G	SHT 5 REMOVED 7" LENGTH IN DESCRIPTION OF ITEM 5	ZA	LS	EW
12/13/18	H	-100 ASSEMBLY: ADDED NOTE 7 ABOUT SLOTS TO ALLOW ITEM 11 SCREWS IN CONDENSER PARTS; -101 & -102: CHANGED LARGE HOLE LENGTH DIMENSION FROM .941 TO .878, ADDED 2X TO DIMENSION ON SHT 11; -105, CHANGED THICKNESS FROM 0.020" TO 0.025", REMOVED THICKNESS CALLOUT ON DRAWING, ADDED 0.05 REFERENCE DIMENSION TO FOLDED TAB DIMENSION IN SECTION C1, ADDED .032 FILETS TO CORNER BENDS;	ZA	LS	ZA
7/5/19	J	-117 PART: REMOVED FLARE CALLOUT. -12 ASSEMBLY: ADDED FLARE OPERATION.	DT	LS	ZA
9/3/19	K	-100 ASSEMBLY FIXED ITEM 21 NAME; -116 & -117: INCREASED WALL TOLERANCE TO 3 PLACES, ADDED ALTERNATE ES PART NO.	ZA	LS	ZA
1/7/21	L	-105 PART: RE-ADDED DETAIL C DIMENSIONS AND MADE CUTOUT LINES SMOOTH FOR CLARITY	ZA	DT	MH
10/14/21	M	-120: CHANGED EXTRUDED RUBBER LENGTH TO 2.1' WAS 2'4"	ZA	DT	ZA

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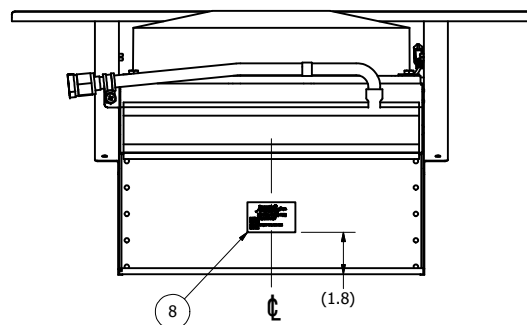
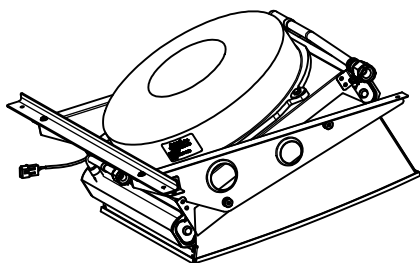
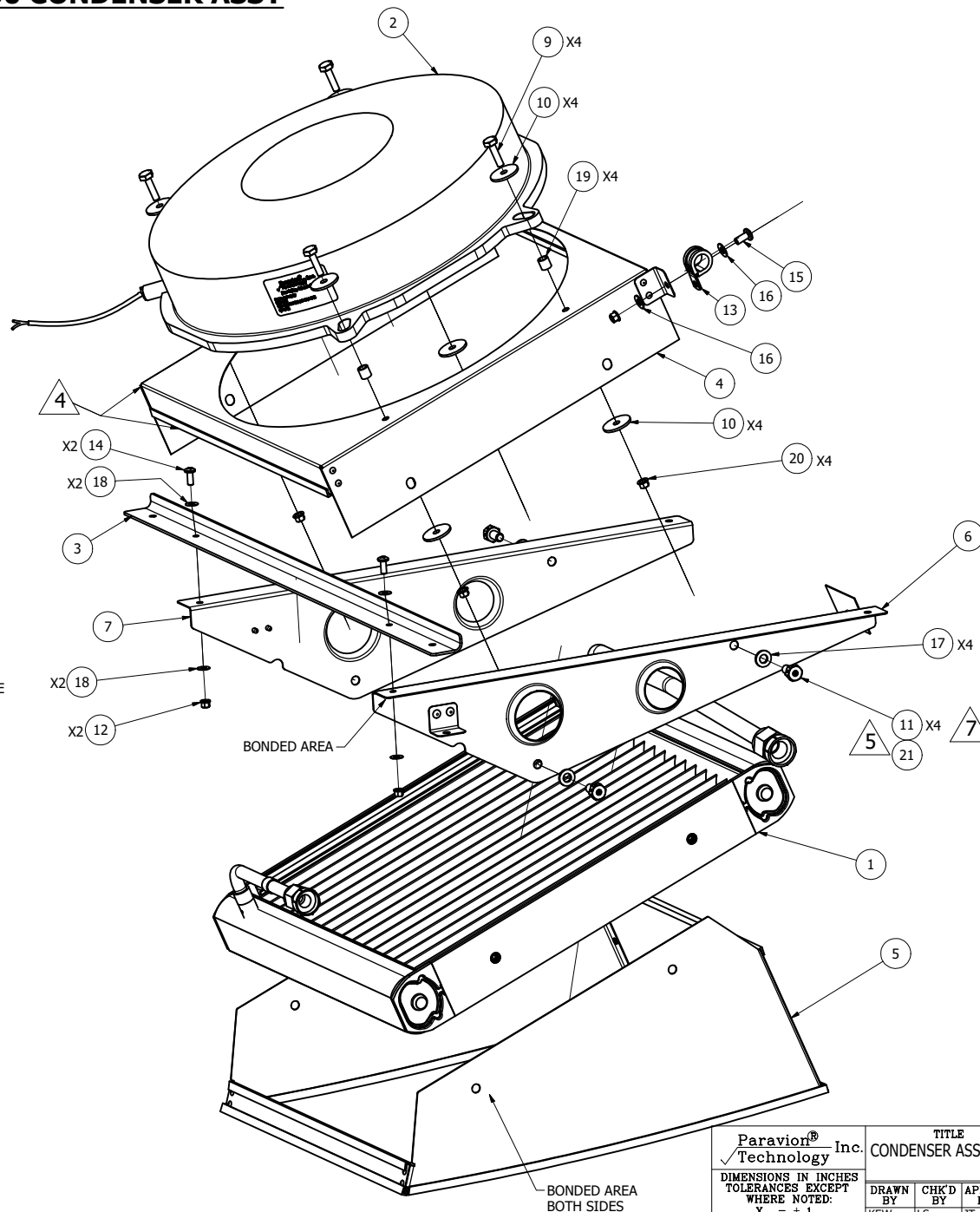
Paravion® Technology Inc.		TITLE CONDENSER ASSEMBLY		DRAWING NUMBER 505AC-2300	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°		DRAWN BY KEW	CHK'D BY LS JT	APRVD. BY	DATE 3/2/16
THREADS: INTERNAL CLASS 2B EXTERNAL CLASS 2A		DO NOT SCALE DRAWING 3RD ANGLE PROJECTION		REV M ECO	
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PARTS LIST

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	505AC-2300-10	CONDENSER COIL ASSY
2	1	505AC-2300-20	CONDENSER FAN ASSY
3	1	505AC-2300-110	CONDENSER FORWARD BRACKET
4	1	505AC-2300-120	CONDENSER PLENUM BOX ASSY
5	1	505AC-2300-121	CONDENSER PLENUM ASSY
6	1	505AC-2300-122	CONDENSER LEFT SIDE ASSY
7	1	505AC-2300-123	CONDENSER RIGHT SIDE ASSY
8	1	505AC-6120-1	LABEL
9	4	AN3-6A	BOLT
10	8	AN970-3	WASHER
11	4	MS20074-04-03	BOLT
12	2	MS21042L08	NUT
13	1	MS21919WDG8	ADEL CLAMP
14	2	MS27039-0806	SCREW
15	1	MS27039-1-06	SCREW
16	2	NAS1149F0332P	WASHER
17	4	NAS1149F0463P	WASHER
18	4	NAS1149FN816P	WASHER
19	4	NAS43DD3-20FC	SPACER
20	5	NAS9926-3L	NUT
21	12in	TIUB01C-33	POLY TUBE

NOTES:

- ENSURE ANODIZE AND PAINT COATINGS BETWEEN PARTS ARE REMOVED AND PREPPED IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-5 THRU 8-7.
 - REFINISH BONDED STRUCTURES IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-25.
 - TEST BONDED RESISTANCE BETWEEN PARTS IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-26, TABLE 8-2 CLASS S.
 - SEAL MATING SURFACES AND CORNERS WITH BLACK SILICONE RTV.
 - SAFETY USING MS20995 Ø0.32 WIRE (& POLY TUBE) PER BHT-ALL-SPM, PARAGRAPH 8-27 THRU 8-29.
 - TORQUE FASTENERS PER BHT-ALL-SPM CHAPTER 4.
- IF NECESSARY SLOT PART HOLES UP TO .250" IN ANY DIRECTION TO ALLOW ITEM 11 SCREWS TO FIT WITH ITEM 1 CONDENSER. REAPPLY PRIMER TO BARE SURFACES PER MFR'S RECOMMENDATIONS.

**-100 CONDENSER ASSY**

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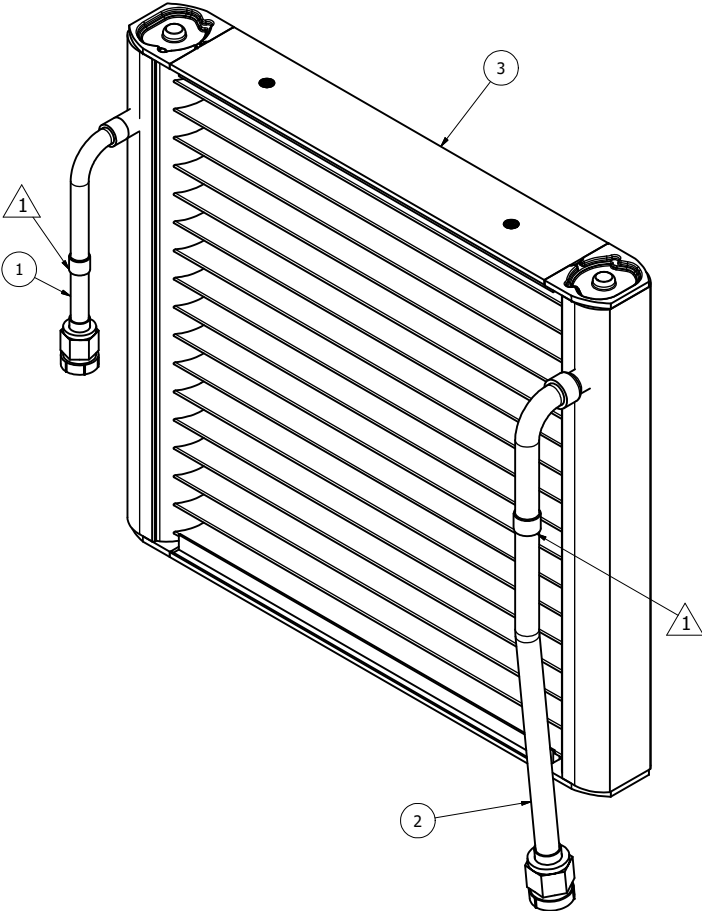
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PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	505AC-2300-11	TUBE ASSY
2	1	505AC-2300-12	TUBE ASSY
3	1	ES90123-1	CONDENSER

NOTES:

1 WELD PER EPS-1003 OR BRAZE PER AWS3.4

-10 CONDENSER COIL ASSY



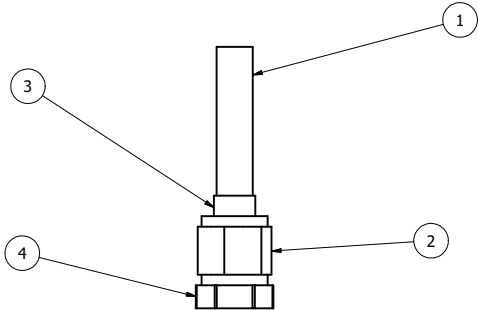
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-11 TUBE ASSEMBLY

PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	505AC-2300-116	TUBE
2	1	AN818-6D	FLARED NUT
3	1	AN819-6D	SLEEVE
4	1	PD60	CAPLUG 3/8" X 9/16-18

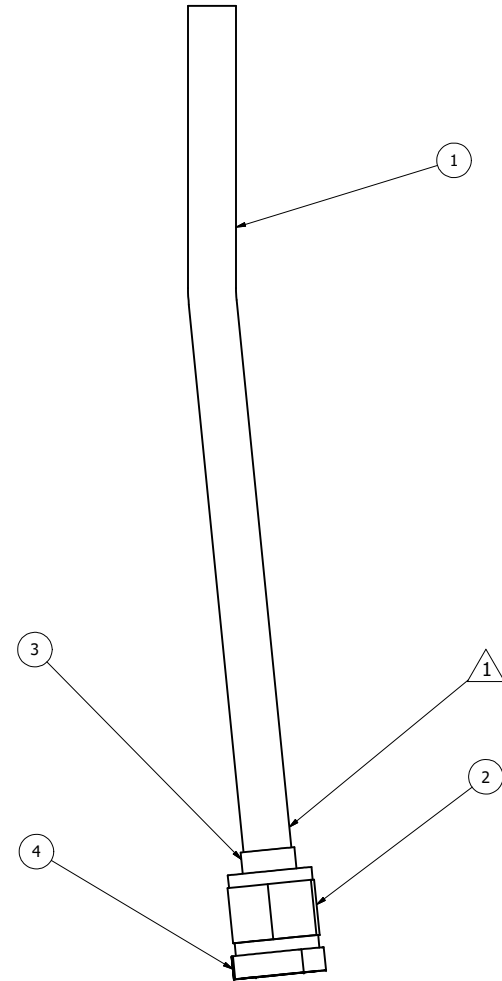


-12 TUBE ASSEMBLY

PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	505AC-2300-117	TUBE
2	1	AN818-8D	FLARED NUT
3	1	AN819-8D	SLEEVE
4	1	PD80	CAPLUG - 1/2" X 3/4-16

NOTES:

INSTALL ITEMS 2 AND 3; THEN FLARE -117
37° PER SAE AS4330.



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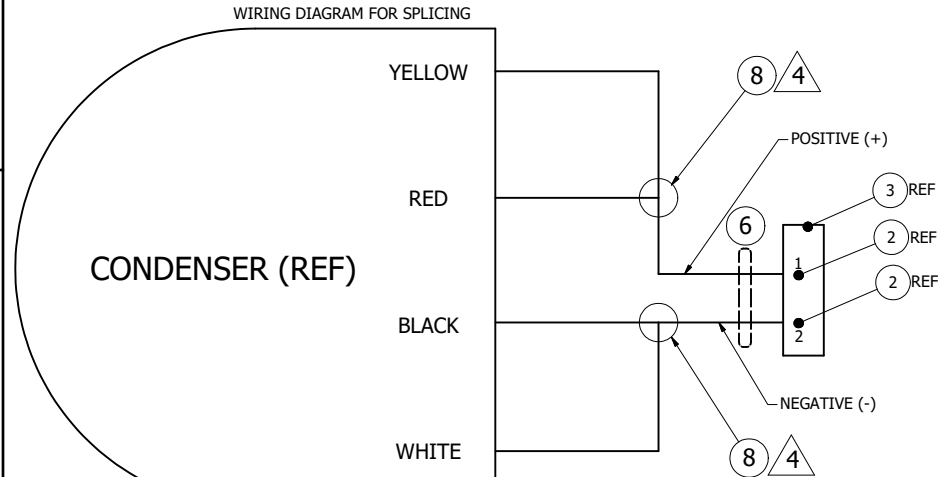
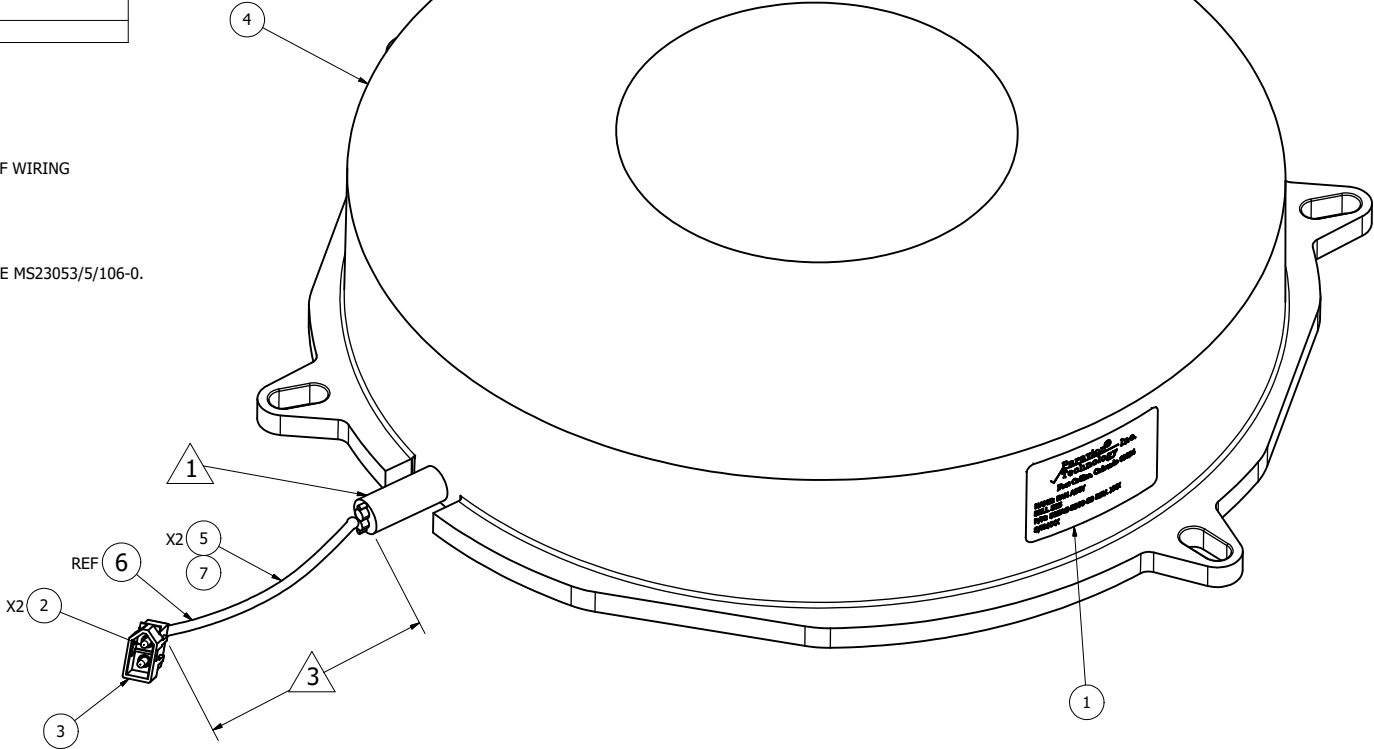
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PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	505AC-6120-5	LABEL
2	2	ES50270-2	TERMINAL, MALE
3	1	ES50272-1	CASE, FEMALE
4	1	ES73201-1	FAN
5	9"	MIL-W-22759/41-16-9	WIRE(ALT. MIL-W-22759/16-16-9)
6	1	505AC-6120-42	2110J1 IDENT SHRINK TUBE
7	6in	M23053/5-107-0	HEAT SHRINK
8	2	M83519/1-3	SOLDER SLEEVE

-20 CONDENSER FAN MODIFIED

- ⚠️ ORIGINAL FAN CONNECTOR TO BE CUT OFF LEAVEING BETWEEN 1"-3" OF WIRING
2. WIRES TO BE SPLICED ACCORDING TO WIRING DIAGRAM
- ⚠️ FINISHED WIRING SHOULD BE APPROXIMATLY 3.5"-8" LONG
- ⚠️ TIN WIRES PER MIL-S-4573E BEFORE CONNECTING WITH SOLDER SLEEVE MS23053/5/106-0.



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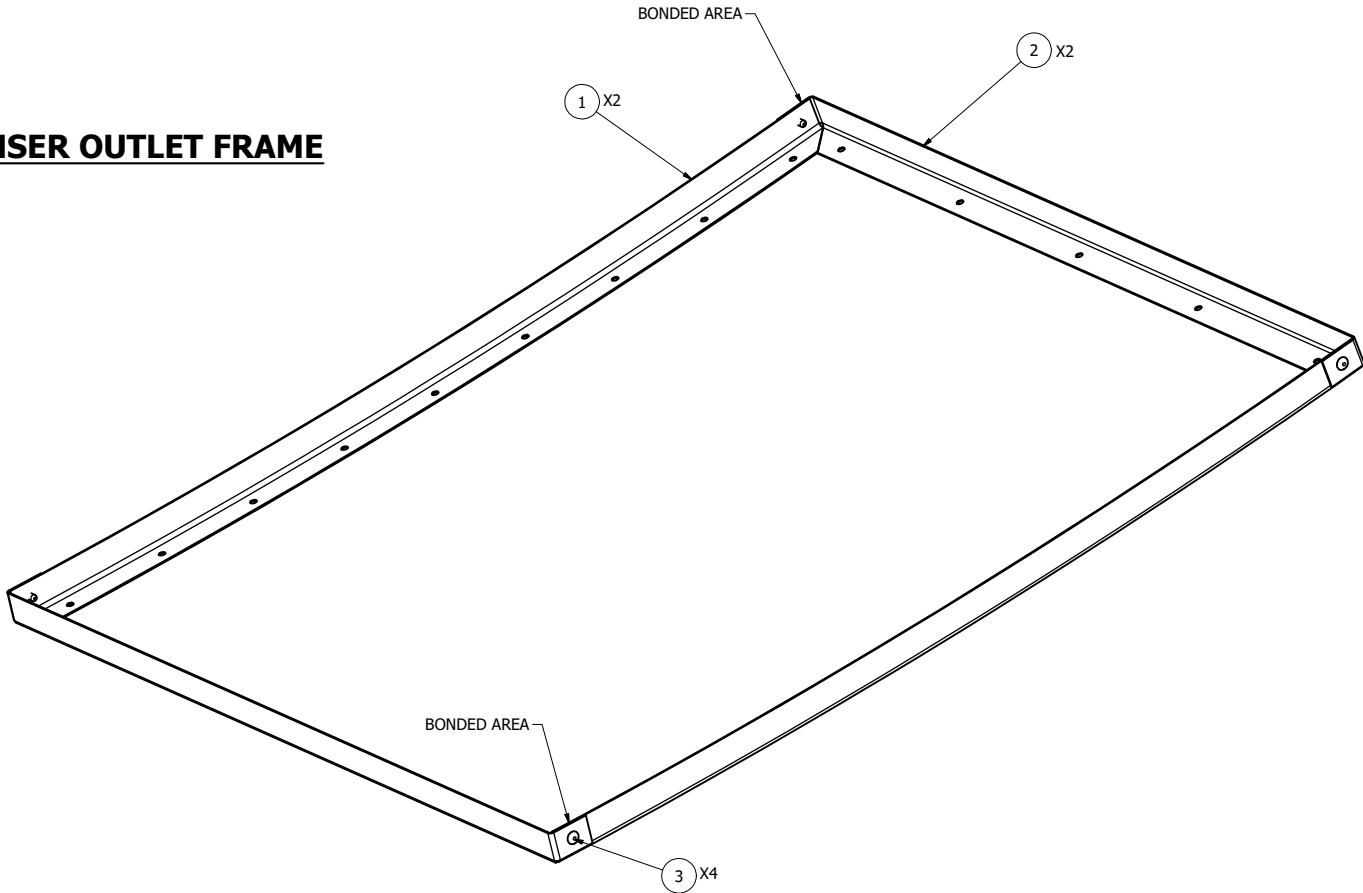
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PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	505AC-2300-106	CONDENSER SIDE FRAME
2	2	505AC-2300-108	FOR/AFT FRAME
3	4	MS20470AD3-2.5	RIVET

- NOTES:
1. WET INSTALL RIVETS WITH PRIMER PER MIL-PRF-23377J TYPE I, CLASS N
 2. ENSURE ANODIZE AND PAINT COATINGS BETWEEN PARTS ARE REMOVED AND PREPPED IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-5 THRU 8-7.
 3. REFINISH BONDED STRUCTURES IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-25.
 4. TEST BONDED RESISTANCE BETWEEN PARTS IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-26, TABLE 8-2 CLASS S.

-109 CONDENSER OUTLET FRAME



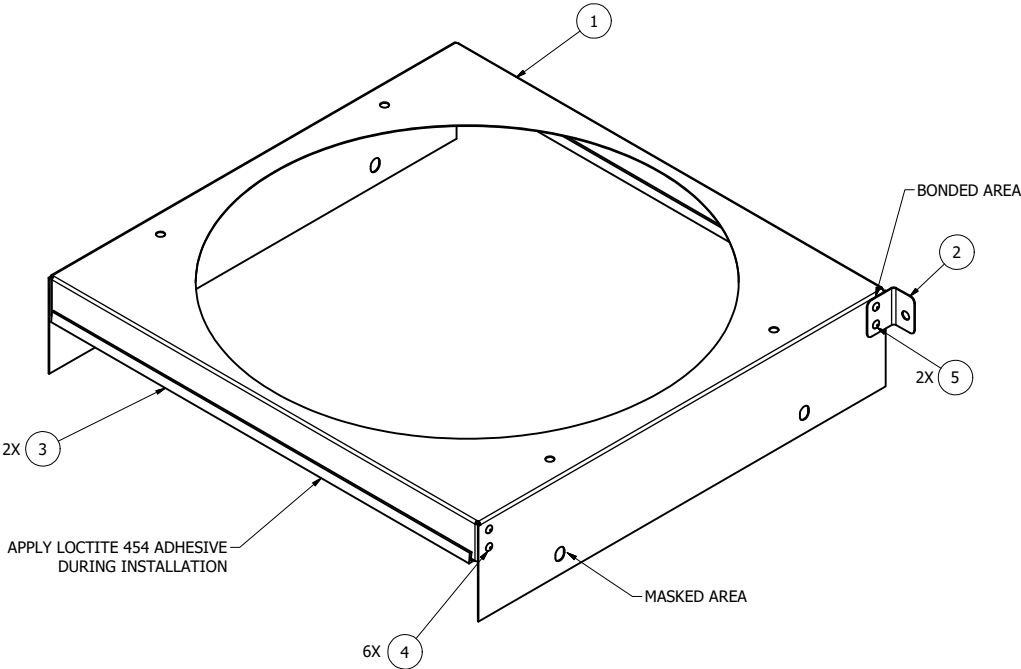
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3RD ANGLE PROJECTION		SHEET 6 OF 23			

PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	505AC-2300-105	BOX
2	1	505AC-2300-127	TUBE SUPPORT
3	2.1'	ES00140-3	EXTRUDED RUBBER
4	6	MS20470AD3-2-5	RIVET
5	2	MS20470AD3-3	RIVET

- NOTES:
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 4. TEST BONDED RESISTANCE BETWEEN PARTS IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-26, TABLE 8-2 CLASS S.



-120 CONDENSER PLENUM BOX

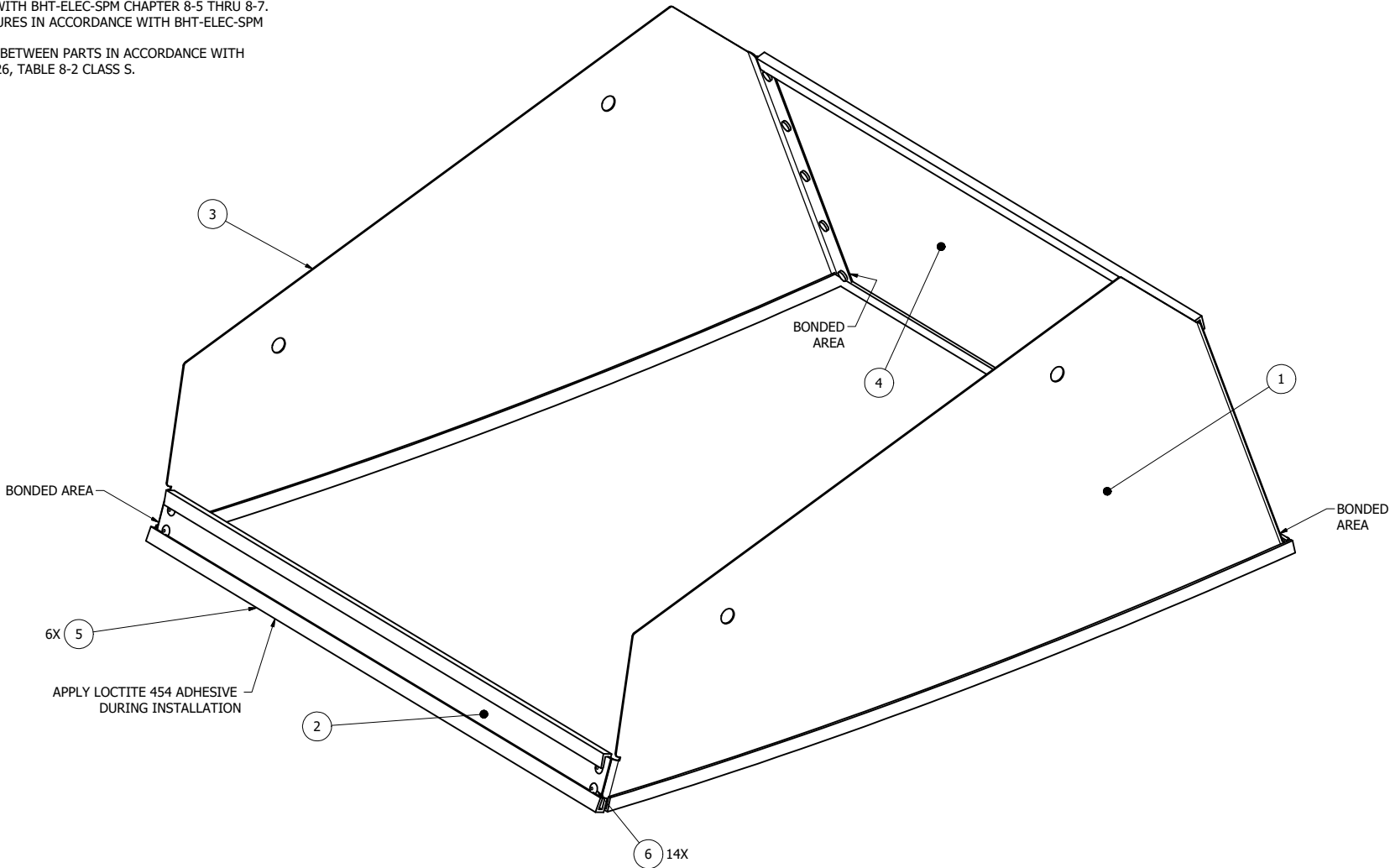
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THREADS: INTERNAL CLASS 2B EXTERNAL CLASS 2A		3RD ANGLE PROJECTION				

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PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	505AC-2300-101	CONDENSER PLENUM LEFT SIDE
2	1	505AC-2300-102	CONDENSER PLENUM FRONT
3	1	505AC-2300-103	CONDENSER PLENUM RIGHT SIDE
4	1	505AC-2300-104	CONDENSER PLENUM AFT
5	6' 6"	ES00140-3	EXTRUDED RUBBER
6	14	MS20470AD3-3	RIVET

- NOTES:
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 3. REFINISH BONDED STRUCTURES IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-25.
 4. TEST BONDED RESISTANCE BETWEEN PARTS IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-26, TABLE 8-2 CLASS S.



-121 CONDENSER OUTLET PLENUM ASSY

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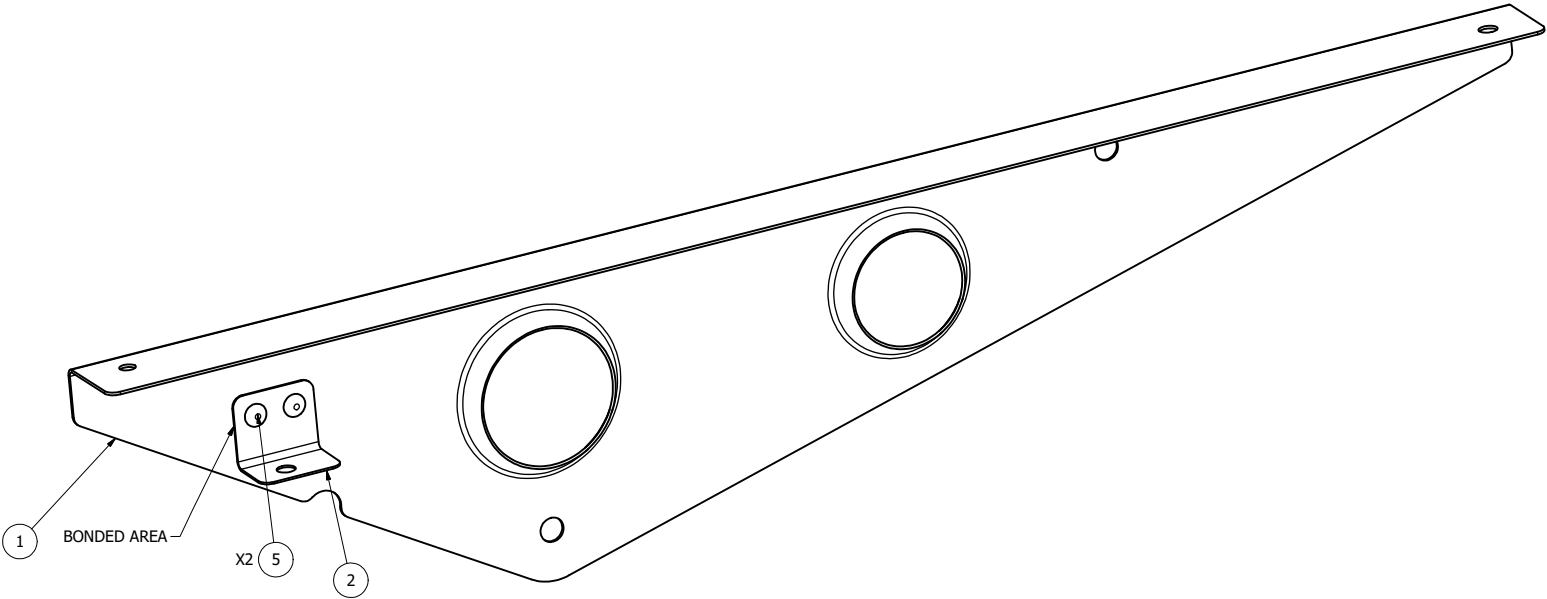
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THREADS: INTERNAL CLASS 2B EXTERNAL CLASS 2A		3RD ANGLE PROJECTION		SHEET 8 OF 23	

PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	505AC-2300-111	CONDENSER LEFT SIDE BRACKET
2	1	505AC-2300-127	TUBE SUPPORT
5	2	MS20470AD4-3-5	RIVET

NOTES:

- WET INSTALL RIVETS WITH PRIMER PER MIL-PRF-23377J TYPE I, CLASS N
- ENSURE ANODIZE AND PAINT COATINGS BETWEEN PARTS ARE REMOVED AND PREPPED IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-5 THRU 8-7.
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- TEST BONDED RESISTANCE BETWEEN PARTS IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-26, TABLE 8-2 CLASS S.
- PAINT: PRIMER PER MIL-PRF-23377J TYPE 1, CLASS N.

-122 CONDENSER LEFT SIDE ASSY



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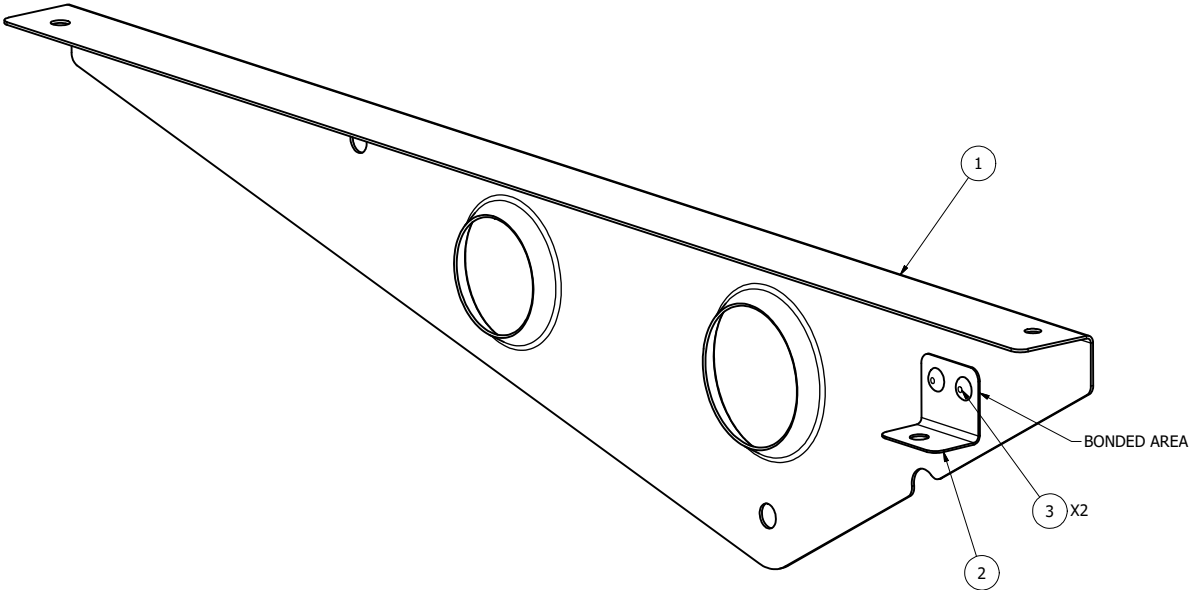
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3RD ANGLE PROJECTION		SHEET 9 OF 23			

PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	505AC-2300-112	CONDENSER RIGHT SIDE BRACKET
2	1	505AC-2300-127	TUBE SUPPORT
3	2	MS20470AD4-3-5	RIVET

NOTES:

1. WET INSTALL RIVETS WITH PRIMER PER MIL-PRF-23377J TYPE I, CLASS N
2. ENSURE ANODIZE AND PAINT COATINGS BETWEEN PARTS ARE REMOVED AND PREPPED IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-5 THRU 8-7.
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5. PAINT: PRIMER PER MIL-PRF-23377J TYPE 1, CLASS N.

-123 CONDENSER RIGHT SIDE ASSY



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3RD ANGLE PROJECTION		SHEET 10 OF 23			

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PROTO

-101 CONDENSER PLENUM LEFT SIDE 10

MATERIAL: 0.020" THK 6061-T6 SHEET PER QQ-A-250/11 AMS 4027, 4026, 4025

FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.

PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.

PAINT ADHESION TEST: 11**NOTES:**10 PREPARE PART FOR PRIMER:

- a. USE EXTRA CAUTION AND WEAR GLOVES WHILE PREPARING PARTS FOR PRIMER.
- b. THOROUGHLY CLEAN ANODIZED PART USING ISOPROPYL ALCOHOL.
- c. USE COMPRESSED AIR FREE OF WATER AND CONTAMINANTS.

11 PAINT ADHESION TEST:

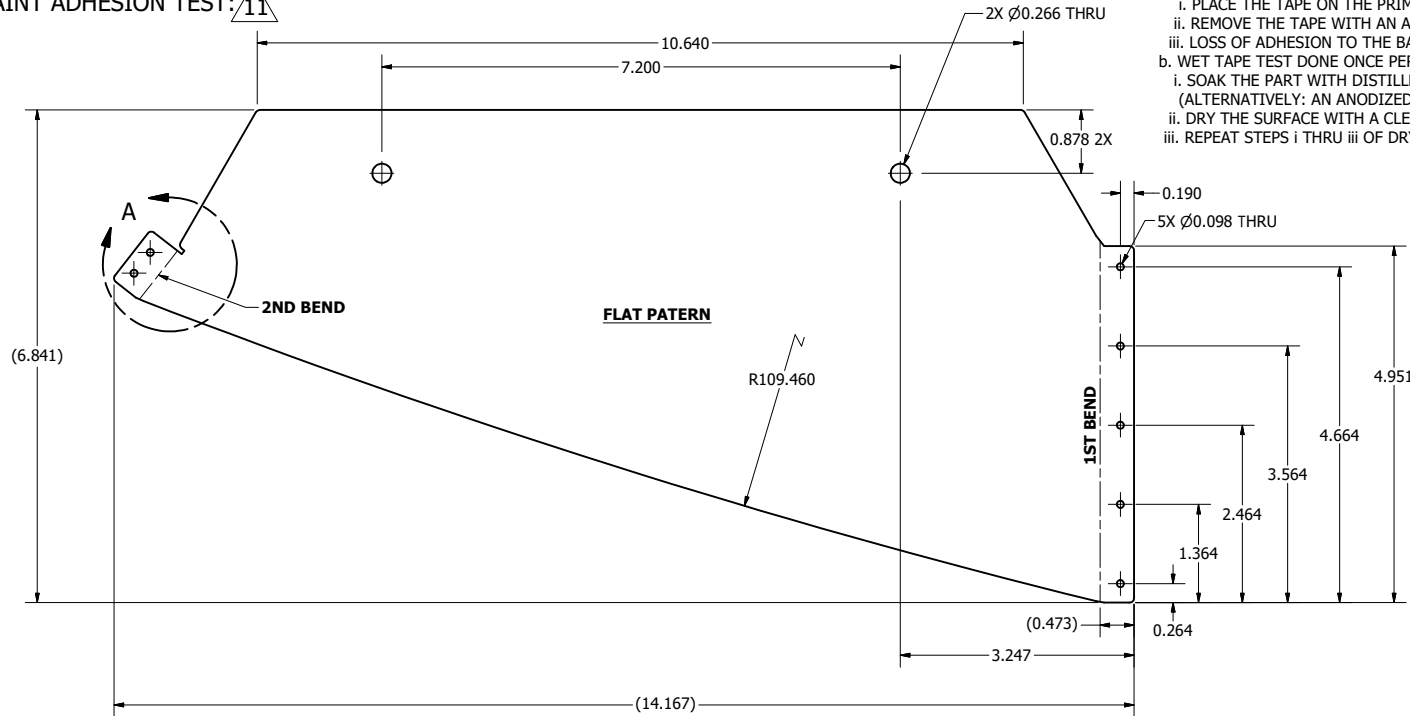
FOR BOTH DRY AND WET TESTS, USE A TAPE WITH AN ADHESION TO STEEL OF 70 OZ/IN MINIMUM.

a. DRY TAPE TEST DONE ONCE EVERY LOT.

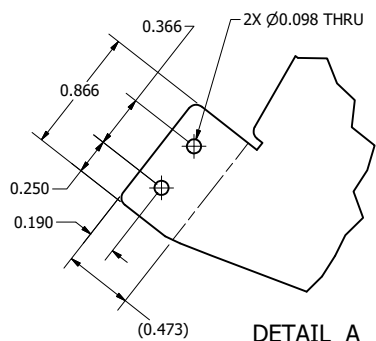
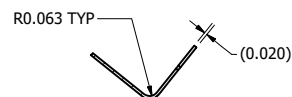
- i. PLACE THE TAPE ON THE PRIMERED SURFACE AND AFFIX WITH FIRM PRESSURE.
- ii. REMOVE THE TAPE WITH AN ABRUPT MOTION (JERK).
- iii. LOSS OF ADHESION TO THE BASE MATERIAL CONSTITUTES A FAILURE.

b. WET TAPE TEST DONE ONCE PER LOT.

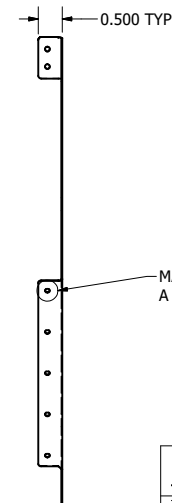
- i. SOAK THE PART WITH DISTILLED OR DEIONIZED WATER FOR 24 HRS.
(ALTERNATIVELY: AN ANODIZED COUPON WITH AN AREA ABOUT 4 INCHES X 4 INCHES MAY BE USED)
- ii. DRY THE SURFACE WITH A CLEAN CLOTH.
- iii. REPEAT STEPS i THRU iii OF DRY TAPE TEST.



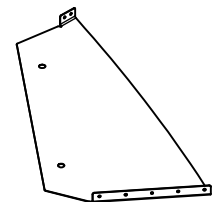
BEND CHART		
	1st BEND	2nd BEND
PUNCH	#21	#21
DIE	#7	#7
ANGLE	90°	90°
DIMENSION	.473	.473

MASK AREA USING
GT00437 DISCS
ON BOTH SIDES.

SECTION B-B



NOTE: THE DRAWING IN COMBINATION WITH THE MODEL 505AC-2300-101 PROVIDE COMPLETE DEFINITION OF THE PART. THE MODEL DEFINES THE BASE GEOMETRY OF THE PART WITHIN $\pm 0.030"$. THE DRAWING IS THE DESIGN MASTER. ANY FEATURE DEFINED ON THE DRAWING SUPERCEEDS ALL MODEL DEFINITION.

**BREAK ALL SHARP EDGES**

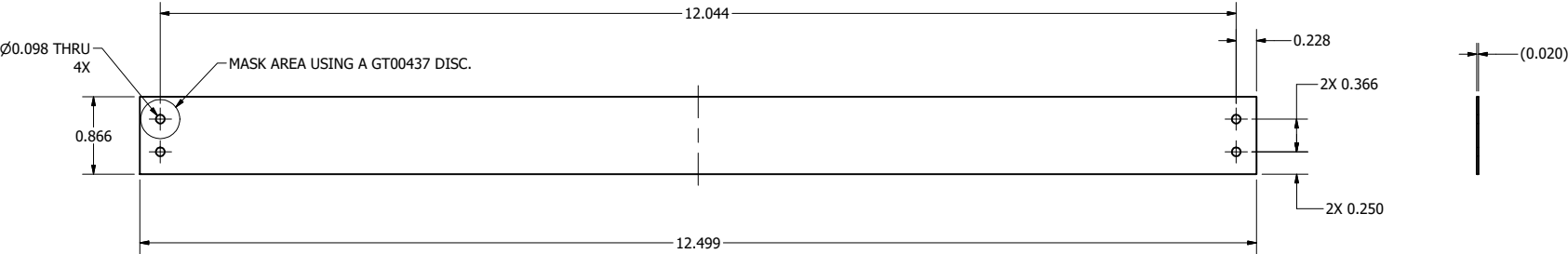
—CONFIDENTIAL INFORMATION—
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PROTO

Paravion® Technology Inc.		TITLE CONDENSER ASSEMBLY		DRAWING NUMBER 505AC-2300	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°		DRAWN BY KEW	CHK'D BY LS	APRVD. BY JT	DATE 3/2/16
THREADS: INTERNAL CLASS 2B EXTERNAL CLASS 2A		DO NOT SCALE DRAWING ©2021 PARAVION TECH. INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.		REV M	ECO
3RD ANGLE PROJECTION		SHEET 11 OF 23			

-102 CONDENSER PLENUM FRONT ¹⁰

MATERIAL: 0.020" THK 6061-T6 SHEET PER QQ-A-250/11 AMS 4027, 4026, 4025
FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.
PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.
PAINT ADHESION TEST: ¹¹



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PROTO

Paravion® Technology Inc.		TITLE CONDENSER ASSEMBLY		DRAWING NUMBER 505AC-2300	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED:		DRAWN BY KEW	CHK'D BY LS	APRVD. BY JT	DATE 3/2/16
.X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°		DO NOT SCALE DRAWING		REV M	ECO
THREADS: INTERNAL CLASS 2B EXTERNAL CLASS 2A		3RD ANGLE PROJECTION		SHEET 12 OF 23	
		©2021 PARAVION TECH. INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.			

-103 CONDENSER PLENUM RIGHT SIDE ¹⁰

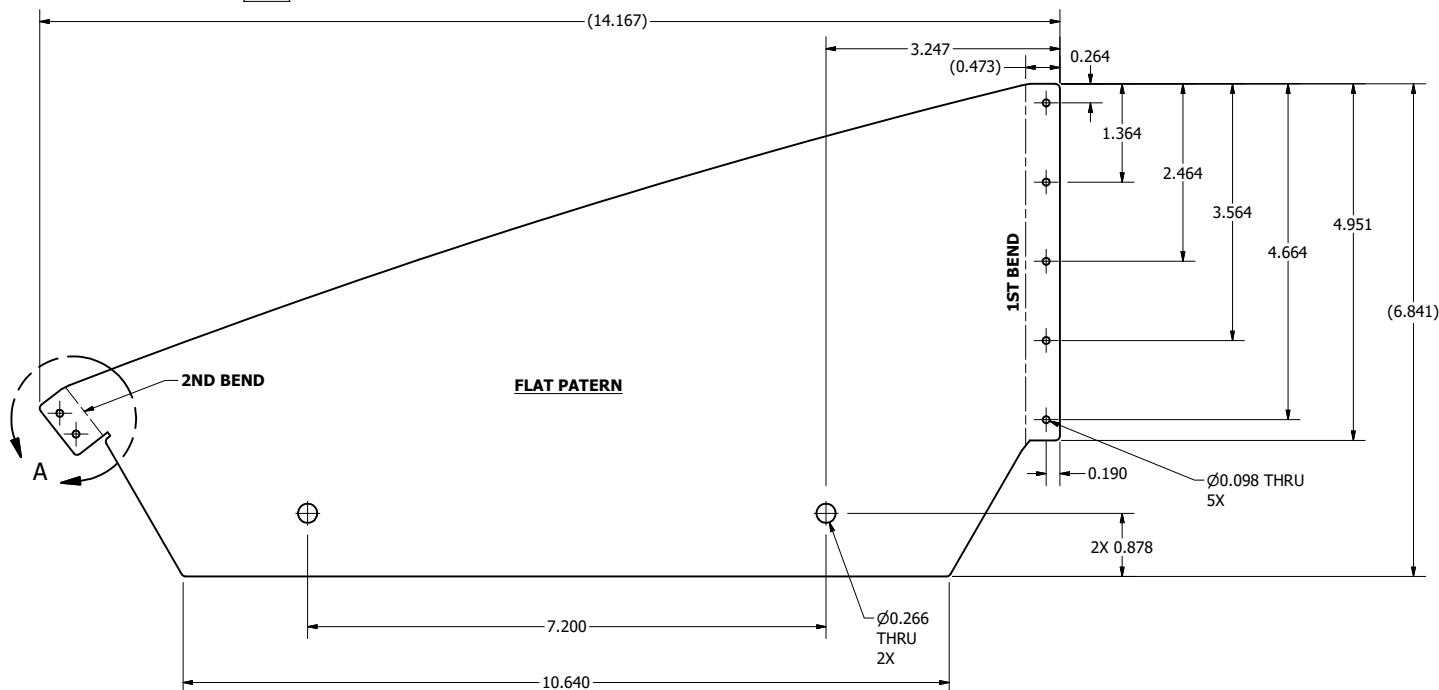
MATERIAL: 0.020" THK 6061-T6 SHEET PER QQ-A-250/11 AMS 4027, 4026, 4025

FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.

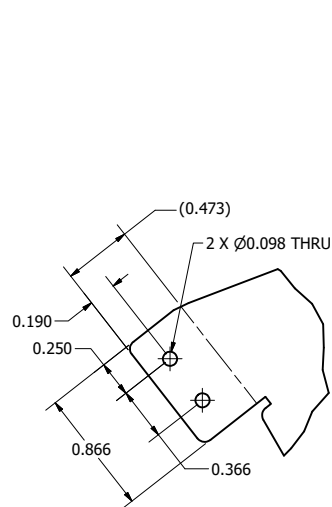
PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.

PAINT ADHESION TEST: ¹¹

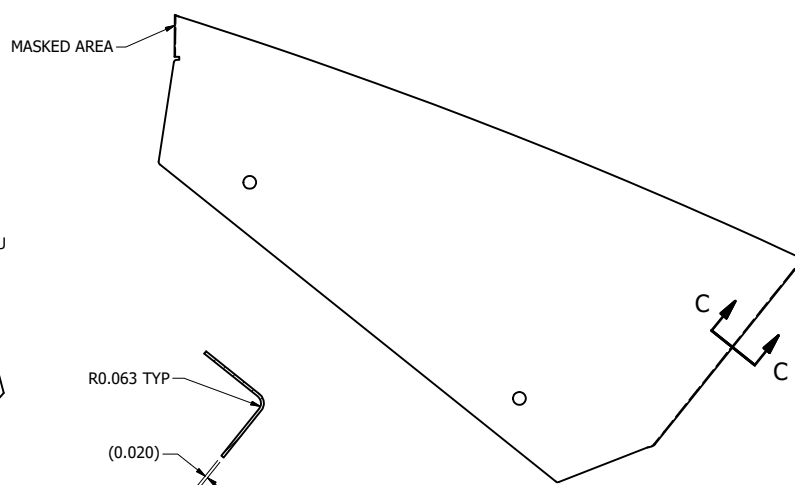
NOTE: THE DRAWING IN COMBINATION WITH THE MODEL 505AC-2300-103 PROVIDE COMPLETE DEFINITION OF THE PART. THE MODEL DEFINES THE BASE GEOMETRY OF THE PART WITHIN $\triangle 0.030"$. THE DRAWING IS THE DESIGN MASTER. ANY FETATURE DEFINED ON THE DRAWING SUPERCEEDS ALL MODEL DEFINITION.



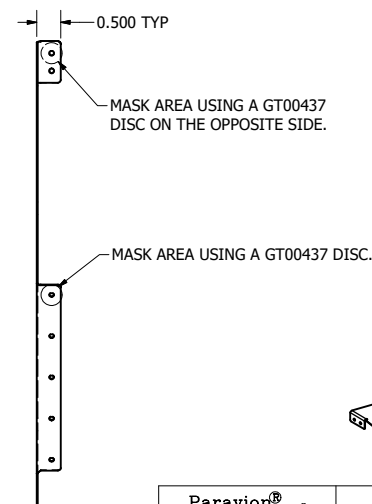
BEND CHART		
	1st BEND	2nd BEND
PUNCH	#21	#21
DIE	#7	#7
ANGLE	90°	90°
DIMENSION	.473	.473



DETAIL A



SECTION C-C

**BREAK ALL SHARP EDGES**

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PROTO

Paravion [®] Technology Inc.		TITLE CONDENSER ASSEMBLY		DRAWING NUMBER 505AC-2300		
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°		DRAWN BY KEW	CHK'D BY LS	APRVD. BY JT	DATE 3/2/16	REV M
THREADS: INTERNAL CLASS 2B EXTERNAL CLASS 2A		DO NOT SCALE DRAWING ©2021 PARAVION TECH. INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.				SHEET 13 OF 23



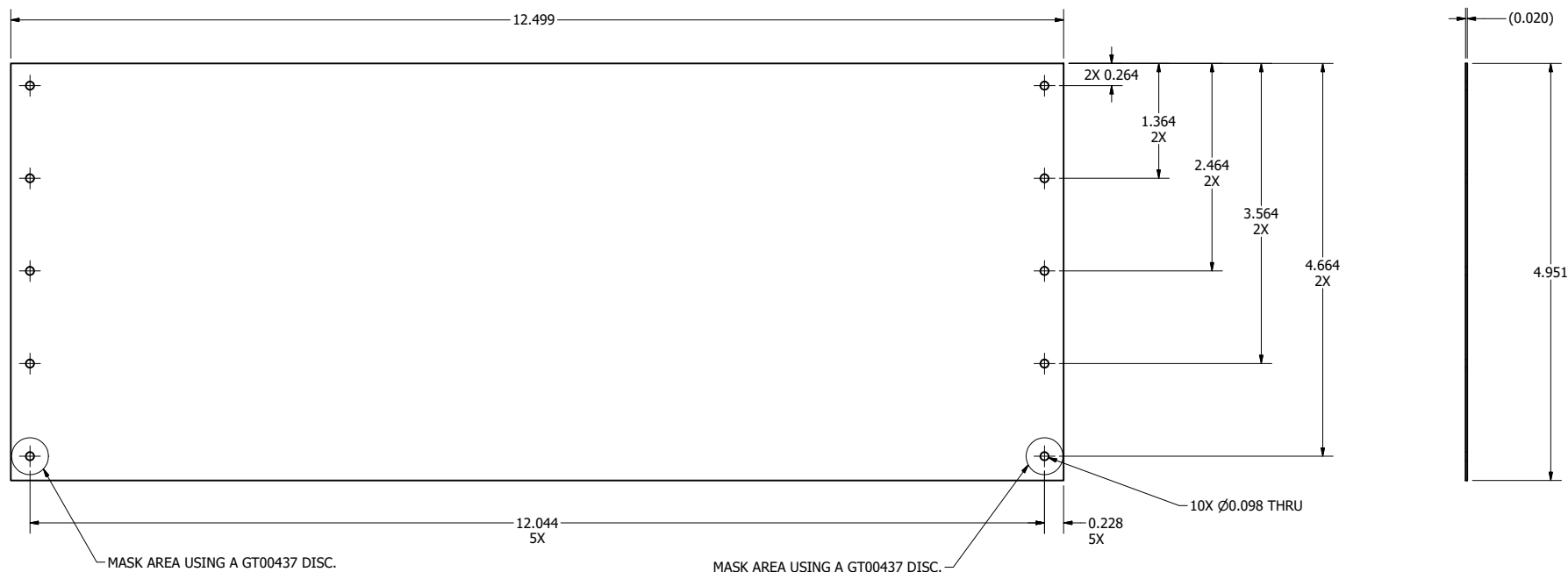
3RD ANGLE PROJECTION

-104 CONDENSER PLENUM AFT ¹⁰

MATERIAL: 0.020" THK 6061-T6 SHEET PER QQ-A-250/11 AMS 4027, 4026, 4025

FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.

PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.

PAINT ADHESION TEST: ¹¹**BREAK ALL SHARP EDGES**

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PROTO

Paravion® Technology Inc.		TITLE CONDENSER ASSEMBLY		DRAWING NUMBER 505AC-2300		
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED:		DRAWN BY KEW	CHK'D BY LS	APRVD. BY JT	DATE 3/2/16	REV M
.X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°		DO NOT SCALE DRAWING				SHEET 14 OF 23
THREADS: INTERNAL CLASS 2B EXTERNAL CLASS 2A		©2021 PARAVION TECH. INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.				
		3RD ANGLE PROJECTION				

-105 CONDENSER PLENUM BOX

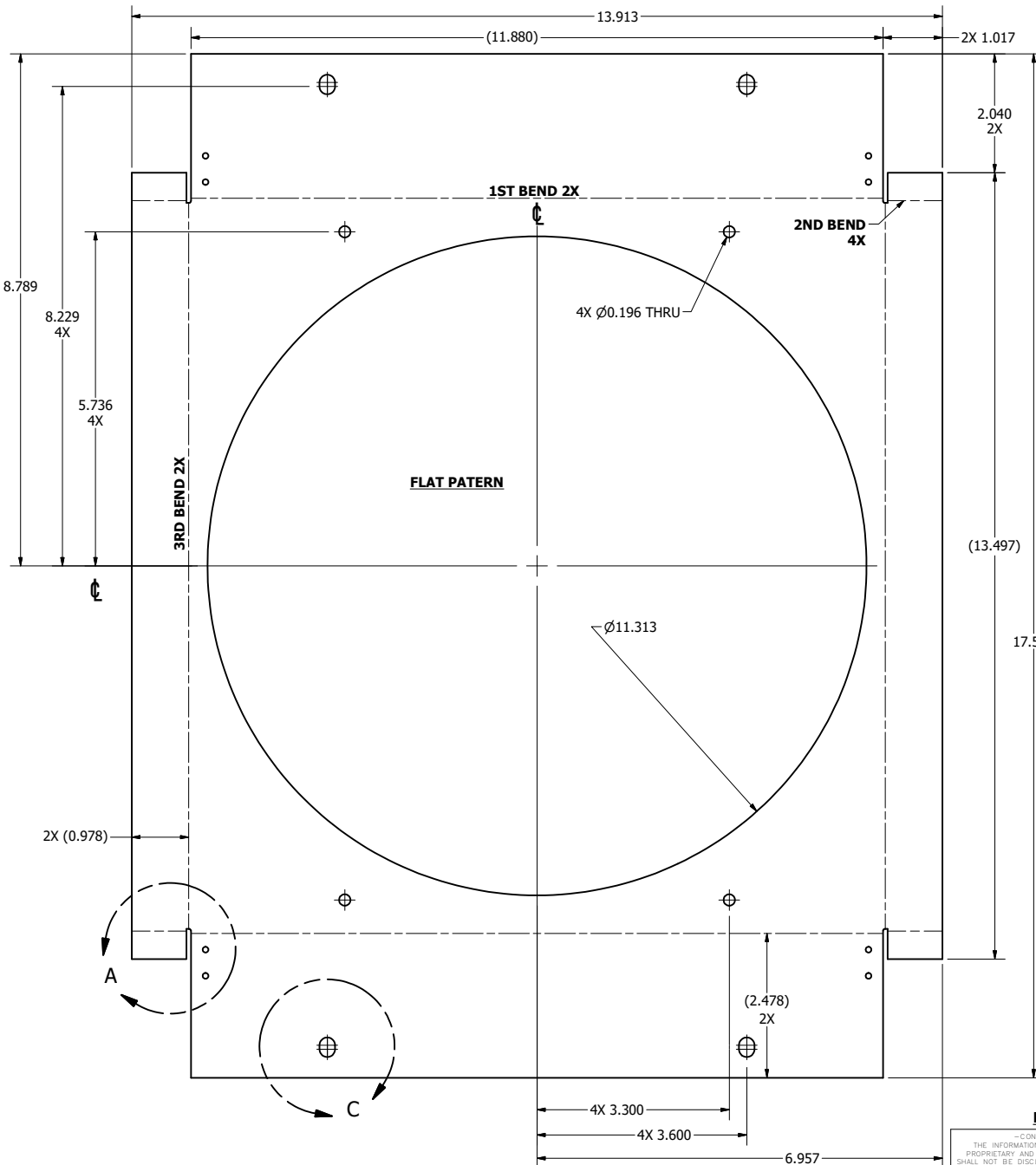
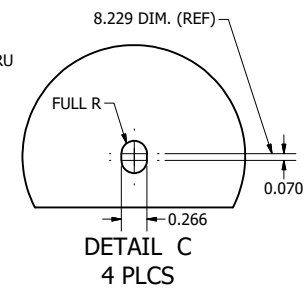
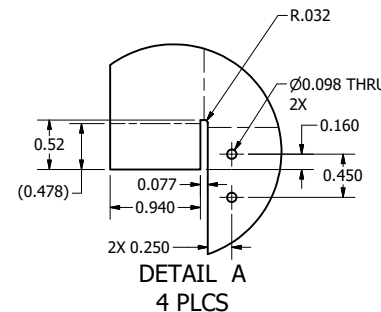
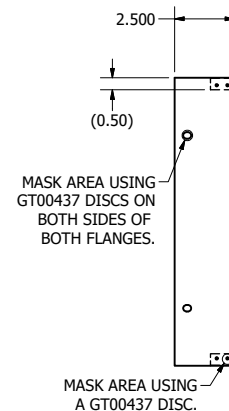
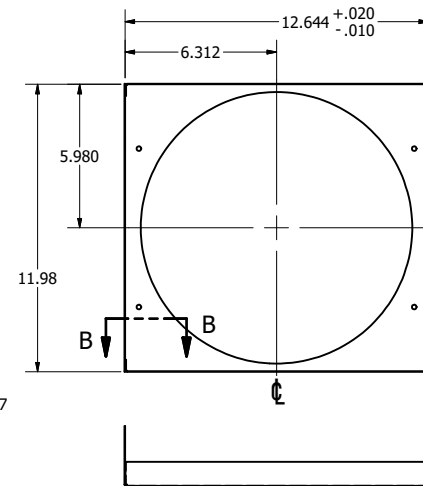
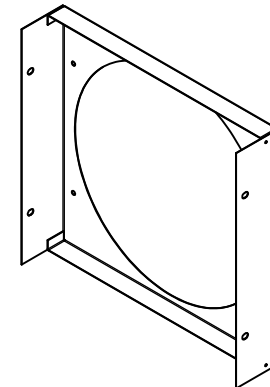
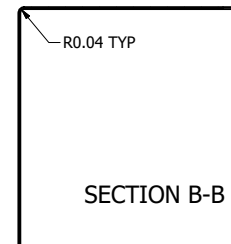
MATERIAL: 0.025" THK 6061-T6 SHEET PER QQ-A-250/11 AMS 4027, 4026, 4025

FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.

PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.

PAINT ADHESION TEST: 11


BEND CHART			
	1st BEND	2nd BEND	3rd BEND
PUNCH	#6	#6	#6
DIE	#15	#15	#1
ANGLE	80°	81°	84°
DIMENSION	2.470	.470	.962



BREAK ALL SHARP EDGES

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<div>Paravion® Technology Inc.</div>		TITLE CONDENSER ASSEMBLY			DRAWING NUMBER 505AC-2300		
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES= ± 1°		DRAWN BY KEW	CHK'D BY LS	APRVD. BY JT	DATE 3/2/16	REV M	ECO
THREADS: INTERNAL CLASS 2B EXTERNAL CLASS 2A		<div> DO NOT SCALE DRAWING ©2021 PARAVION TECH. INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.</div>				SHEET 15 OF 23	
		3RD ANGLE PROJECTION					

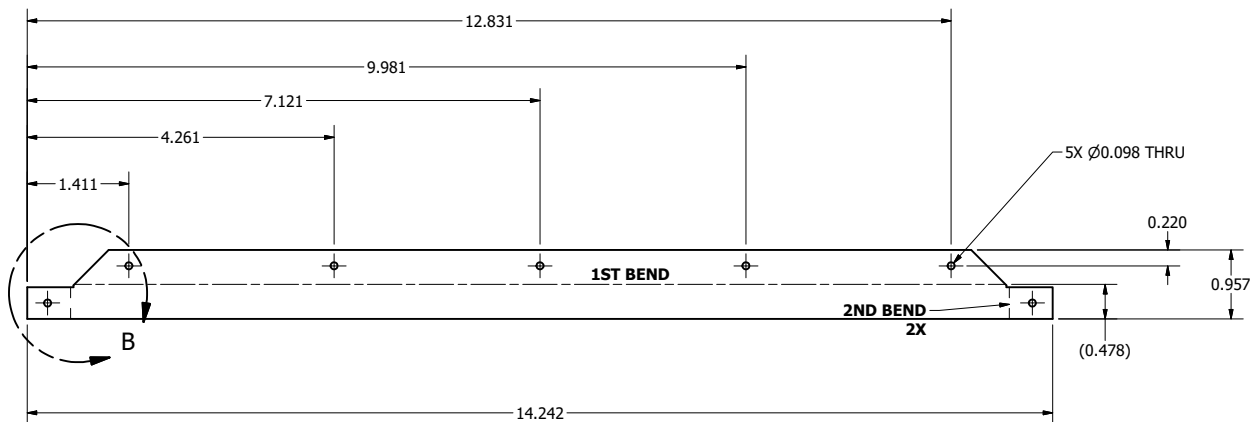
-108 FOR/AFT FRAME

MATERIAL: 0.020" THK 6061-T6 SHEET PER QQ-A-250/11 AMS 4027, 4026, 4025

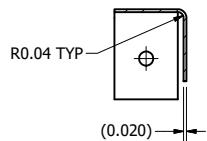
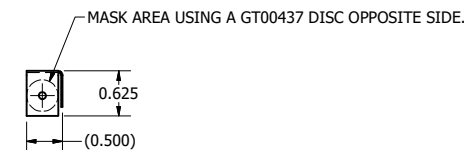
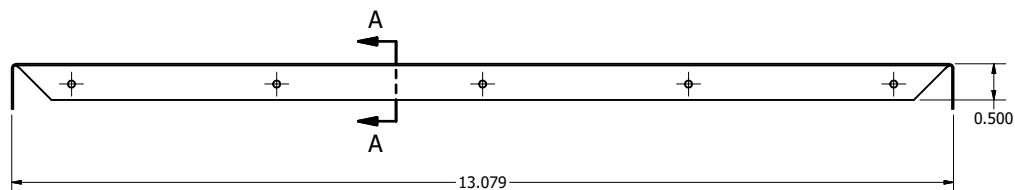
FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.

PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.

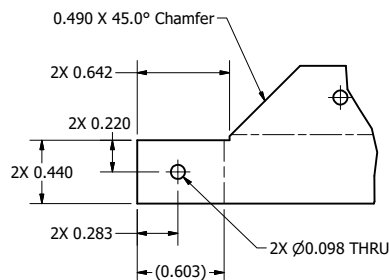
PAINT ADHESION TEST: 11

FLAT PATTERN

BEND CHART		
	1st BEND	2nd BEND
PUNCH	#21	#21
DIE	#1	#1
ANGLE	90°	92°
DIMENSION	.469	.592



SECTION A-A



DETAIL B

BREAK ALL SHARP EDGES

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PROTO

Paravion® Technology Inc.		TITLE CONDENSER ASSEMBLY		DRAWING NUMBER 505AC-2300	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°		DRAWN BY KEW	CHK'D BY LS	APRVD. BY JT	DATE 3/2/16
THREADS: INTERNAL CLASS 2B EXTERNAL CLASS 2A		DO NOT SCALE DRAWING ©2021 PARAVION TECH. INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.		REV M	ECO
3RD ANGLE PROJECTION		SHEET 17 OF 23			

-110 CONDENSER FORWARD BRACKET $\triangle 10$

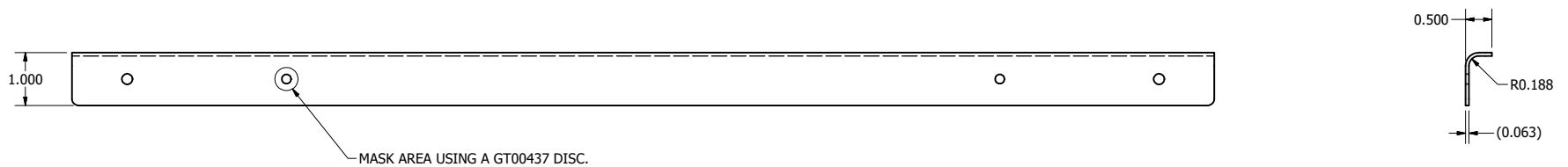
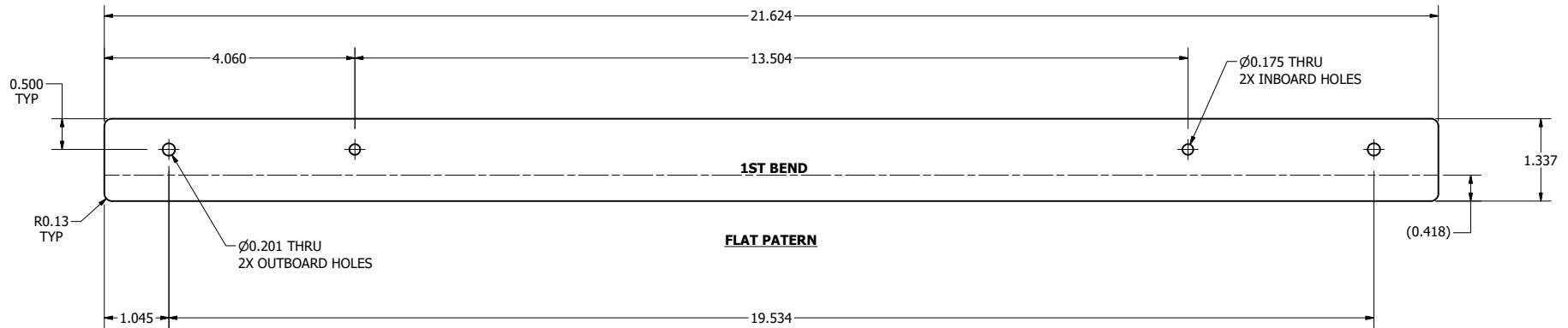
MATERIAL: 0.063" THK 6061-T6 SHEET PER QQ-A-250/11 AMS 4027, 4026, 4025

FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.

PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.

PAINT ADHESION TEST: $\triangle 11$

BEND CHART	
	1st BEND
PUNCH	#10
DIE	#1
ANGLE	68°
DIMENSION	.420

**BREAK ALL SHARP EDGES**

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PROTO

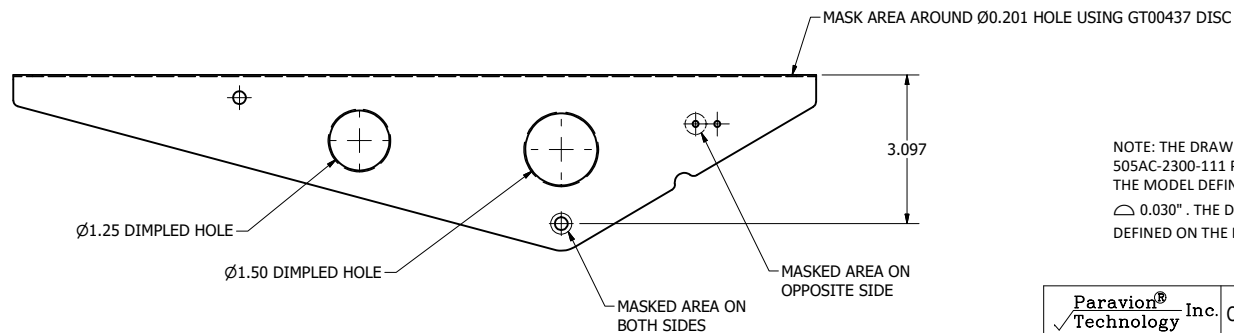
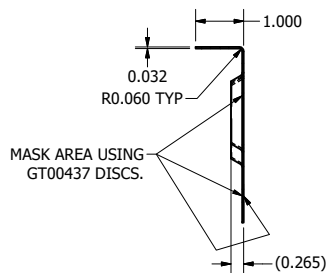
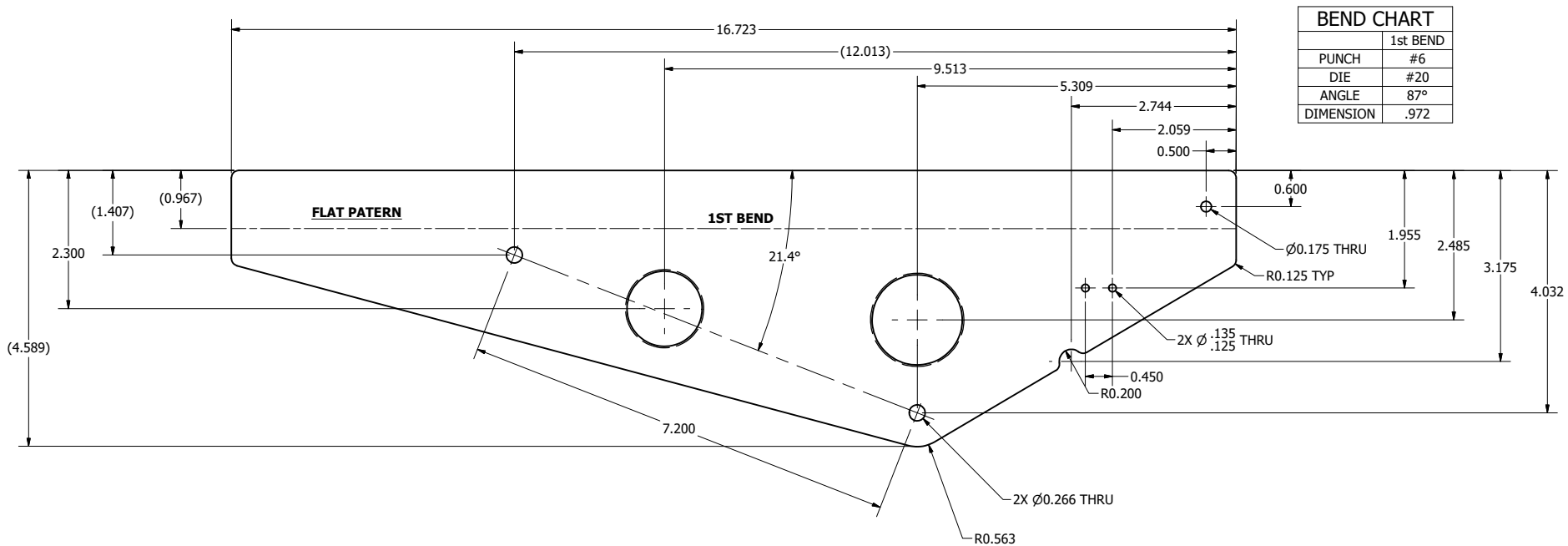
Paravion® Technology Inc.		TITLE CONDENSER ASSEMBLY		DRAWING NUMBER 505AC-2300	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED:		DRAWN BY KEW	CHK'D BY LS	APRVD. BY JT	DATE 3/2/16
.X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°		DO NOT SCALE DRAWING		REV M	ECO
THREADS: INTERNAL CLASS 2B EXTERNAL CLASS 2A		3RD ANGLE PROJECTION		SHEET 18 OF 23	
		©2021 PARAVION TECH. INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.			

-111 CONDENSER LEFT SIDE BRACKET ¹⁰

MATERIAL: 0.032" THK 6061-T6 SHEET PER QQ-A-250/11 AMS 4027, 4026, 4025

FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.

PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.

PAINT ADHESION TEST: ¹¹

NOTE: THE DRAWING IN COMBINATION WITH THE MODEL 505AC-2300-111 PROVIDE COMPLETE DEFINITION OF THE PART. THE MODEL DEFINES THE BASE GEOMETRY OF THE PART WITHIN $\triangle 0.030"$. THE DRAWING IS THE DESIGN MASTER. ANY FEATURE DEFINED ON THE DRAWING SUPERCEDES ALL MODEL DEFINITION.

BREAK ALL SHARP EDGES

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PROTO

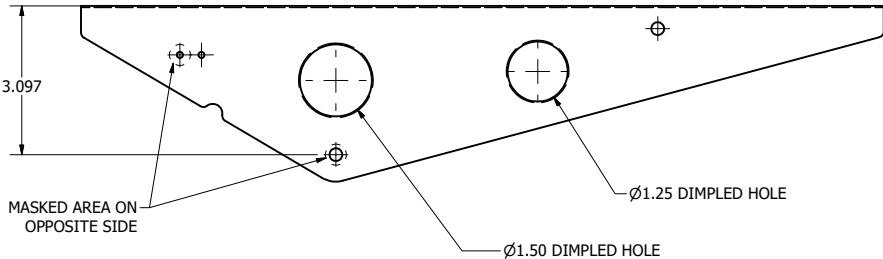
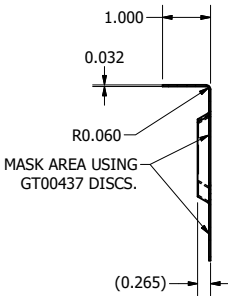
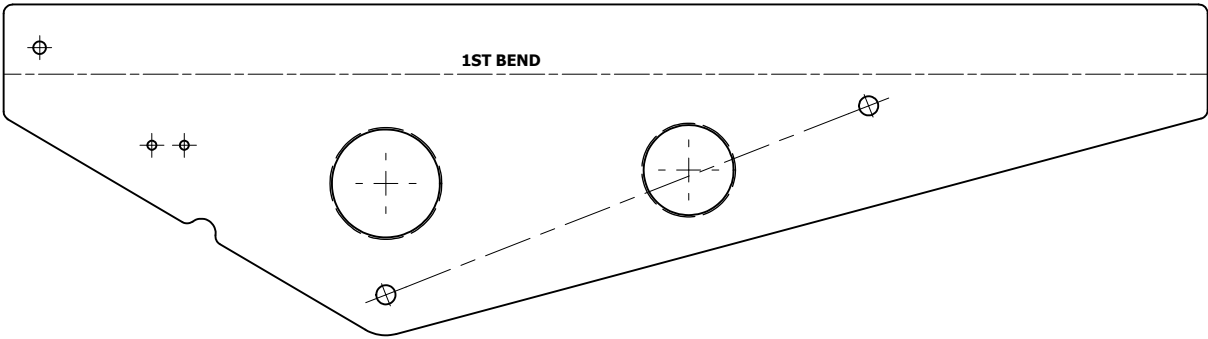
Paravion® Technology Inc.		TITLE CONDENSER ASSEMBLY			DRAWING NUMBER 505AC-2300	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°		DRAWN BY KEW	CHK'D BY LS	APRVD. BY JT	DATE 3/2/16	REV M
THREADS: INTERNAL CLASS 2B EXTERNAL CLASS 2A		DO NOT SCALE DRAWING				SHEET
3RD ANGLE PROJECTION		©2021 PARAVION TECH INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.				19 OF 23

-112 CONDENSER RIGHT SIDE BRACKET 10

MATERIAL: 0.032" THK 6061-T6 SHEET PER QQ-A-250/11 AMS 4027, 4026, 4025
FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.
PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.
PAINT ADHESION TEST: 11

BEND CHART	
	1st BEND
PUNCH	#6
DIE	#20
ANGLE	87°
DIMENSION	.972

FLAT PATTERN
SAME AS -111



NOTE: THE DRAWING IN COMBINATION WITH THE MODEL 505AC-2300-112 PROVIDE COMPLETE DEFINITION OF THE PART. THE MODEL DEFINES THE BASE GEOMETRY OF THE PART WITHIN $\pm 0.030"$. THE DRAWING IS THE DESIGN MASTER. ANY FETATURE DEFINED ON THE DRAWING SUPERCEEDS ALL MODEL DEFINITION.

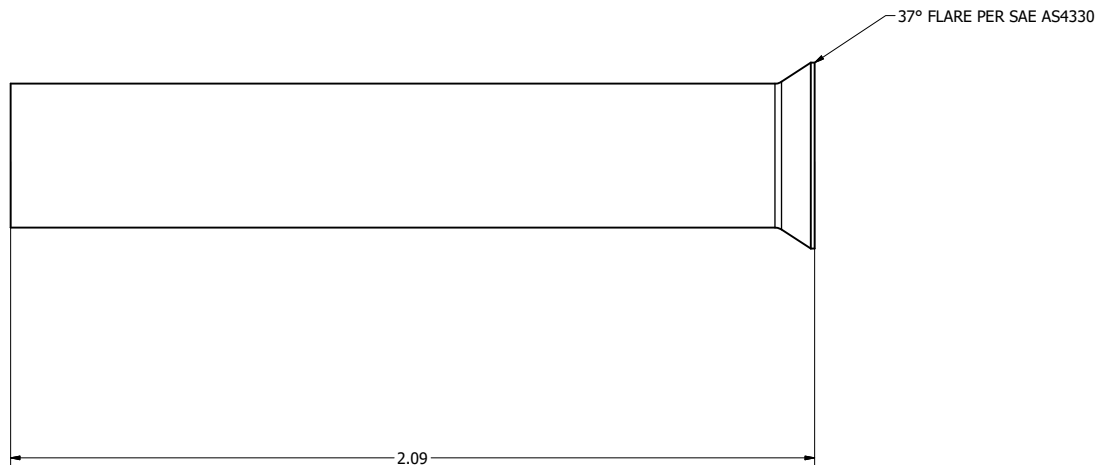
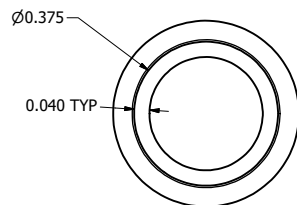
BREAK ALL SHARP EDGES

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PROTO

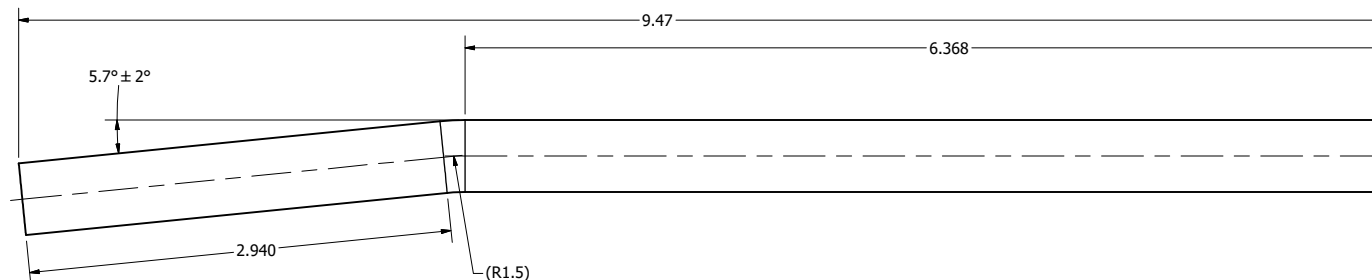
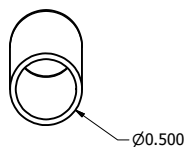
Paravion® Technology Inc.		TITLE CONDENSER ASSEMBLY		DRAWING NUMBER 505AC-2300	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED:		DRAWN BY KEW	CHK'D BY LS	APRVD. BY JT	DATE 3/2/16
.X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°		DO NOT SCALE DRAWING		REV M	ECO
THREADS: INTERNAL CLASS 2B EXTERNAL CLASS 2A		3RD ANGLE PROJECTION		SHEET 20 OF 23	
				©2021 PARAVION TECH. INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.	

FINISH: NONE



BREAK ALL SHARP EDGES

FINISH: NONE




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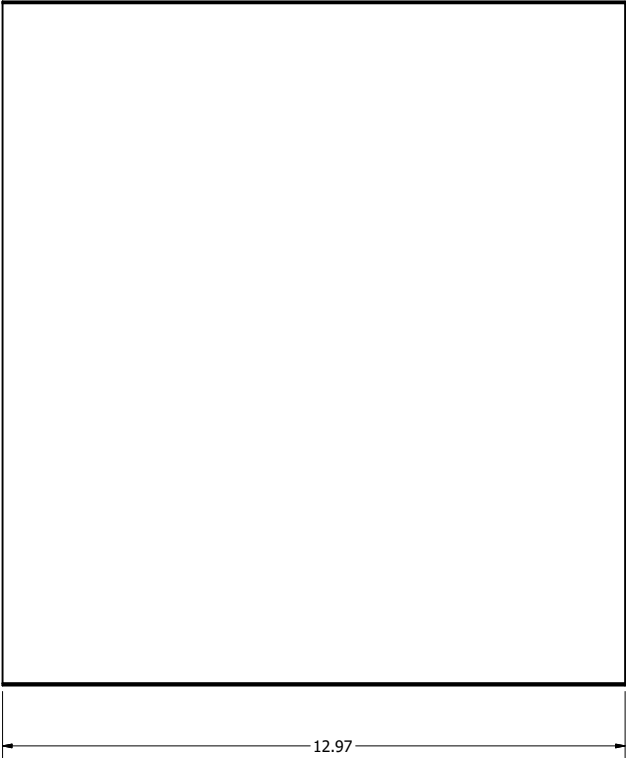
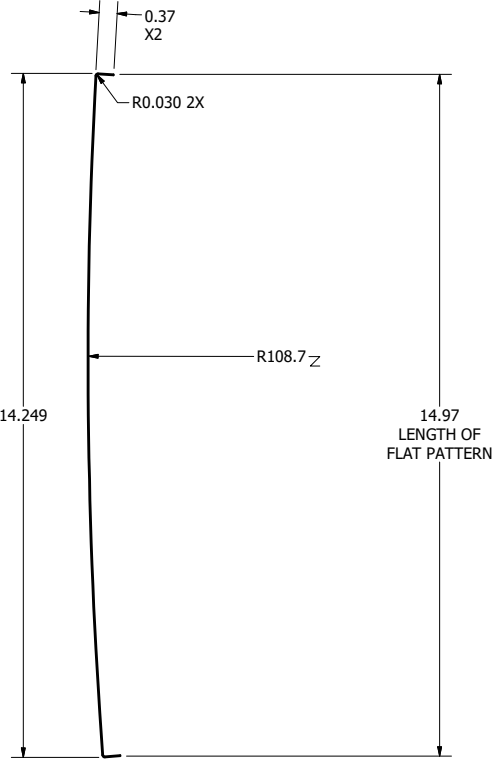
	PROTC
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Paravion® Technology Inc.	TITLE				DRAWING NUMBER	
	CONDENSER ASSEMBLY				505AC-2300	
	DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED:				REV	ECO
	DRAWN BY	CHK'D BY	APRV. BY	DATE		
.X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES ± 1°	KEW	LS	JT	3/2/16	M	
THREADS: INTERNAL CLASS 2B EXTERNAL CLASS 2A	 DO NOT SCALE DRAWING © 2021 PARAVION TECH INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.				SHEET	
	3RD ANGLE PROJECTION				21 OF 23	

-119 SCREEN

MAKE FROM: ES04071-1 (MATERIAL 304S. ST.)
FINISH: NONE

BOTH BENDS
PUNCH #21
DIE #7
ANGLE @ 87°
DIMENSION .320



BREAK ALL SHARP EDGES

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Paravion® Technology Inc.		TITLE CONDENSER ASSEMBLY		DRAWING NUMBER 505AC-2300	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°		DRAWN BY KEW	CHK'D BY LS	APRVD. BY JT	DATE 3/2/16
THREADS: INTERNAL CLASS 2B EXTERNAL CLASS 2A		DO NOT SCALE DRAWING ©2021 PARAVION TECH. INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.		REV M	ECO
3RD ANGLE PROJECTION		SHEET 22 OF 23			

